

Work Order ID: 81420

March-14-12 7:54:11 AM

Rush

81420

Page 1

Item ID: D3494-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Stub Cover

Start Date: 14/03/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 28/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/14 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw.Nbr	Revision Nbr
D3494	Rev D

100		0.00
-----	--	------

100

Waterjet
FLOW CNC Waterjet

Memo

1-Cut as per Dwg
Dwg Rev: D
Prog Rev: D

2-Deburr if necessary

0.00

12 0 Jm
12-5-22

110	QC2- Inspect parts off machine FAI/FAIB	0.00
-----	---	------

110

QC
Quality Control

Memo

0.00

12 0 Jm
12-5-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(12)			WHL 12-05-23
130 *130* Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00				(12)			SG 12-05-21
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				12			WHL 12-05-31

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 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
144 *144* Large Fab	Weld per dwg A/R S.S. rod Batch: <u>12602</u>	0.00		12		8/12/CC		12-6-5	
Large Fab	Memo 1- WELD 2- GRIND AS PER DWG	0.00							
146 *146* QC	QC10- Inspect visual per QSI004- ground welds	0.00							
Quality Control	Memo	0.00				12x			
147 *147* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00				(12)			

W/O:		WORK ORDER CHANGES					
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Page 4

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 Required Date: 28/03/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating M121279	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo	0.00 0.00				12X			MK 12/06/07
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				12	6	1267	
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>51224</u> Memo	0.00 0.00				12		500 12/06/07	

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Work Order ID 81420***81420***

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Cust Item ID:

Required Date: 28/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

U120607

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Picklist Print

March-14-12 7:54:16 AM

Page 1

Work Order ID: 81420

81420

Parent Item: D3494-1

D3494-1

Parent Item Name: Stub Cover

Start Date: 14/03/2012

Required Date: 28/03/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A New Issue 06-05-18 JLM

IPP rev B ecn 888 06.12.13 EC

add welding DD 10.03.03 verifie by:EC

chg design EC verified by:DD

IPP Rev:C

Ipp RevD ECN 10-555

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	254.4860	0.72	7.578947			

M304S16GA

304/316 Sheet .063

**

Location

MAT020

119653

120866

120877

Loc Qty

254.486

17.35

78

159.136

Loc Code

121626

121626

Jm
12-5-22

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DART AEROSPACE LTD		Work Order:	81420
Description: Stub Cover		Part Number:	D3494-1
Inspection Dwg: D3494	Rev: D	Page 1 of 1	

☒ **First Article** ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.208	+/-0.010	0.202	✓		✓	HB-02
0.368	+/-0.010	0.377	✓		✓	HB-02
0.766	+/-0.010	0.770	✓		✓	HB-02
2.568 2.528	+/-0.010	2.528				
6.278	+/-0.010	6.283	✓		✓	HB-02
8.039	+/-0.010	8.043	✓		✓	HB-02
8.437	+/-0.010	8.446	✓		✓	HB-02
8.805	+/-0.010	8.813	✓		✓	HB-02
1.832	+/-0.010	1.838	✓		✓	HB-02
3.262	+/-0.010	3.271	✓		✓	HB-02
3.604	+/-0.010	3.605	✓		✓	HB-02
3.940	+/-0.010	3.948	✓		✓	HB-02
7.544	+/-0.010	7.546	✓		✓	HB-02
7.887	+/-0.010	7.889	✓		✓	HB-02
9.317	+/-0.010	9.322	✓		✓	HB-02
11.148	+/-0.010	11.158	✓		✓	HB-02
0.060	+/-0.010	0.056	✓		✓	HB-02

Measured by: JM	Audited by: [Signature]	Preliminary Approval:
Date: 12-5-22	Date: 12-5-23	Date:

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	10.02.18	Dimensions updated per Dwg Rev C	KJ	
C	11.04.28	Dimensions updated per Dwg Rev D	KJ	[Signature]

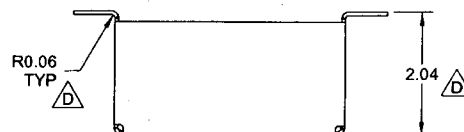
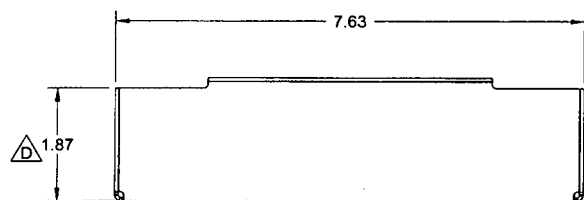
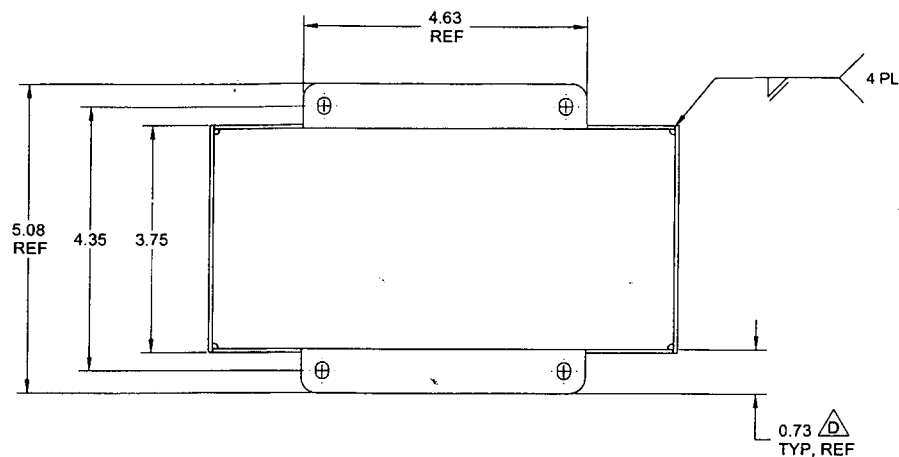
Dart Aerospace Ltd

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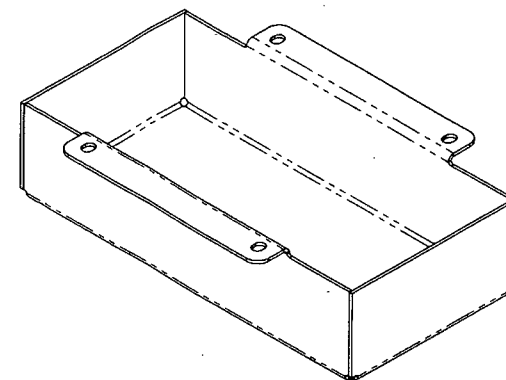
D3494-1 STUB COVER

NOTES:

- 1) MATERIAL: MAKE FROM D3494-1F
- 2) FINISH: POWDER COAT BLACK SANDETEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3494-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.29 lbs
- 8) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 81420 MLJ
12/03/14



RELEASED
2010-04-26
WJ

D	TOLERANCE WAS 3 DEC. PLACES (ZN B5-1); 1.87 WAS 1.88 (ZN B8-1), 2.04 WAS 2.00 (ZN B3-1), REVISED D3494-1F (ZN A8-2), CORRECTED WEIGHT INFO (ZN A8-1), UPDATED MATERIAL (ZN A8-2) REASON: SEE NCR#10-037.	MB	10.04.15
C	DRAWING TRANSFERRED TO "B" SIZE. GENERAL REVISION TO FLAT PATTERN SEE PREVIOUS REV FOR DETAILS. C8-1 DIM 5.08 WAS 5.05 AND WAS A "HARD CALLOUT". C5-1 0.87 DIM WAS 0.85, B8-1 1.90 DIM WAS 1.86 B3-1 & 2.04 DIM WAS 2.00. REFER TO PAR 08-003 FOR FURTHER DETAILS.	AJS	08.10.31
B	REVISED FLAT PATTERN, BENDING DIMENSIONS, Ø0.208 X 0.268 SLOTS WERE Ø0.208 HOLES.	MB	06.11.28
A	NEW ISSUE	MB	06.01.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3494** REV. D
SHEET 1 OF 2
TITLE **STUB COVER** SCALE NTS

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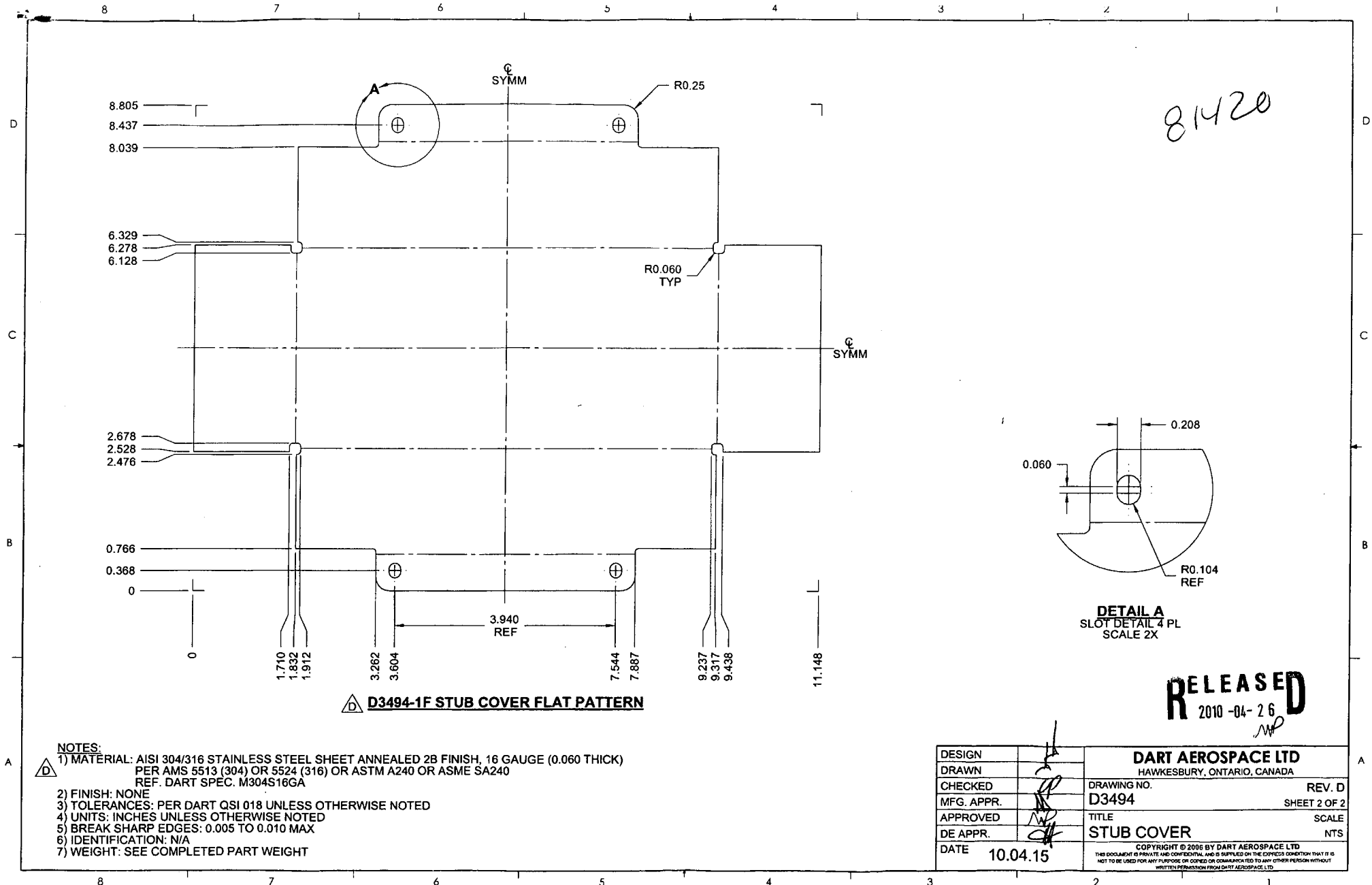
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RELEASED
2010-04-26
MP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3494	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STUB COVER	NTS
DATE	10.04.15	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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